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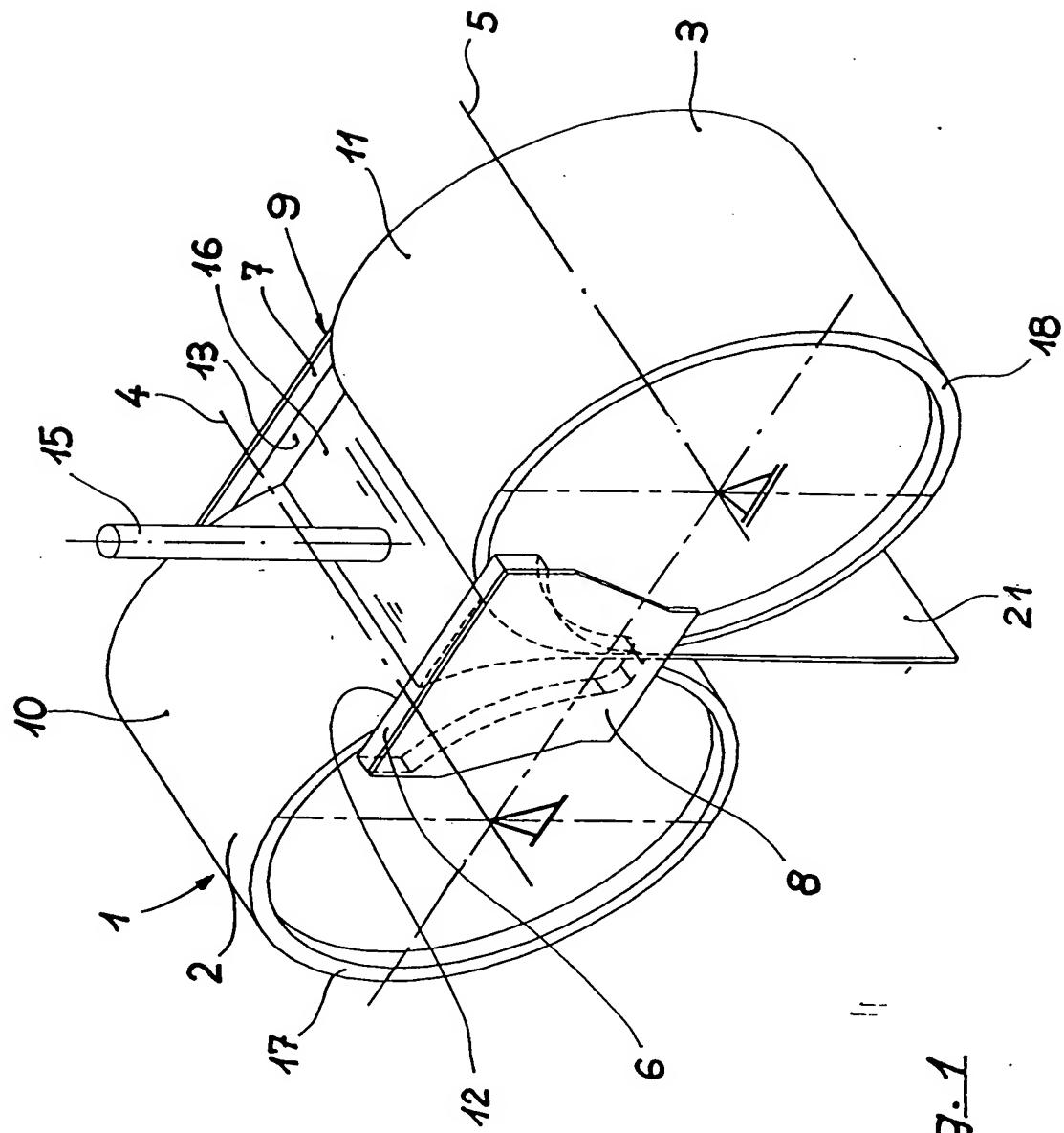


Fig. 1

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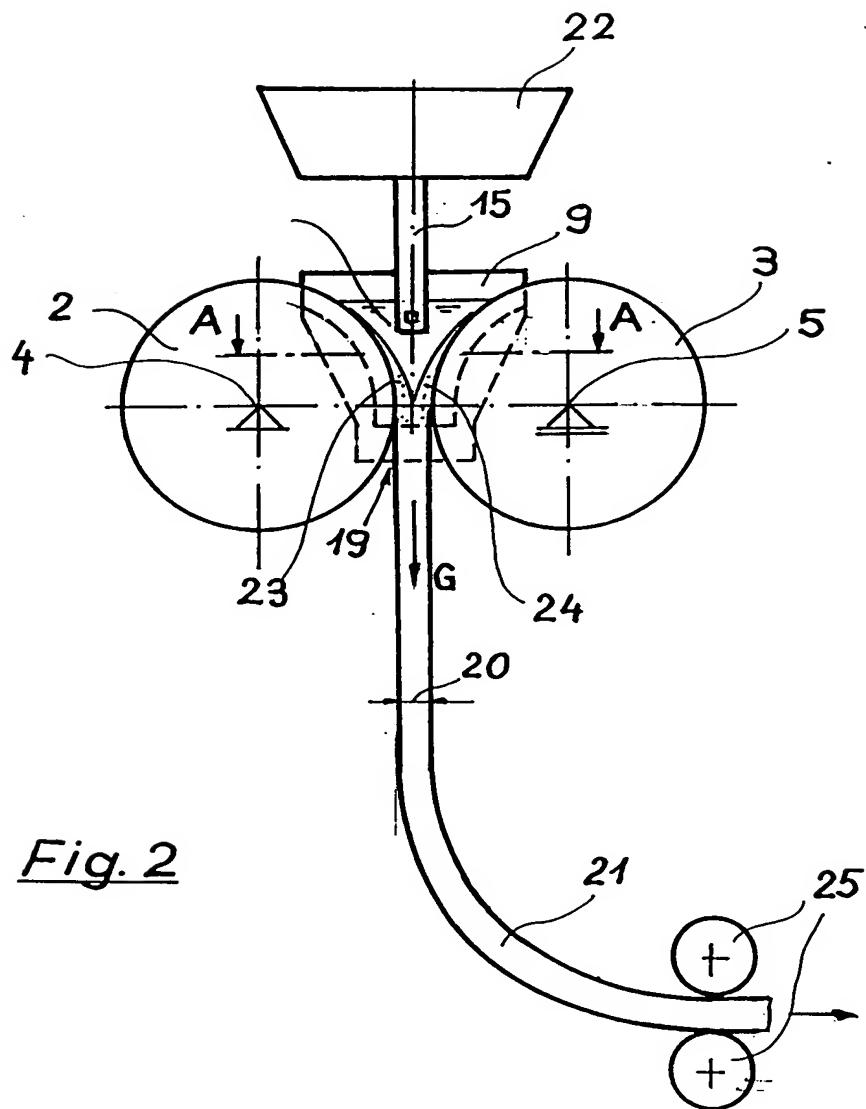
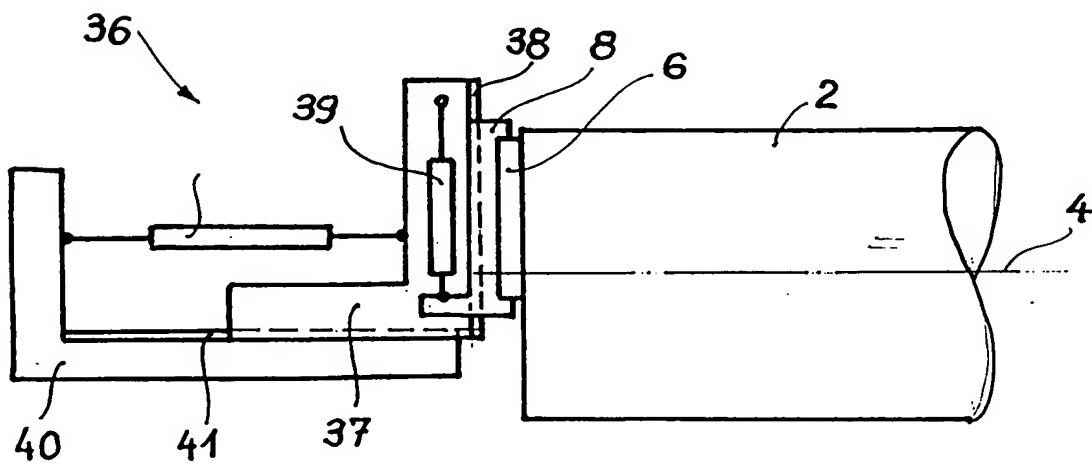
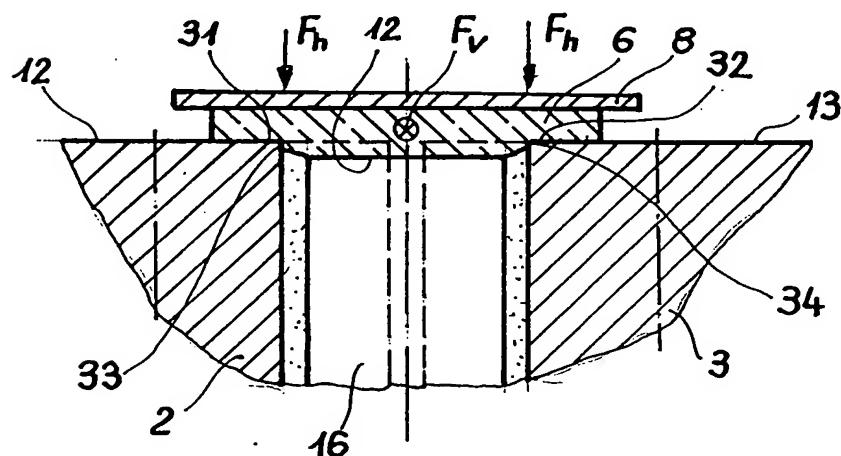
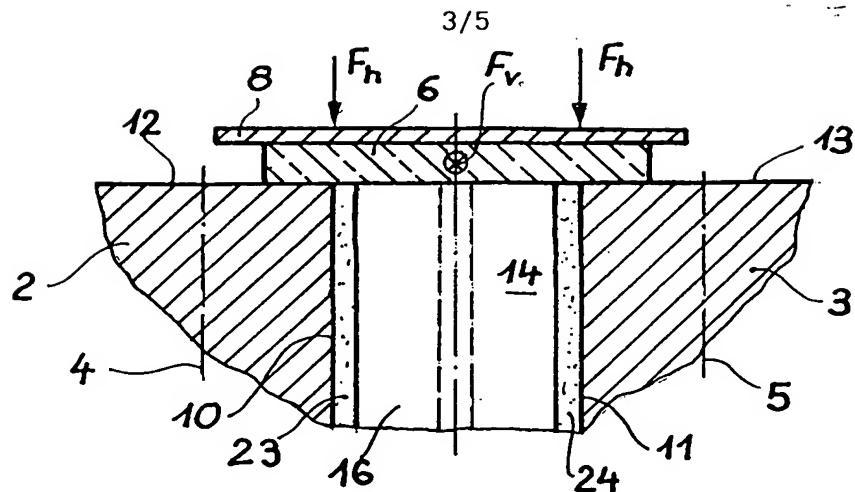


Fig. 2

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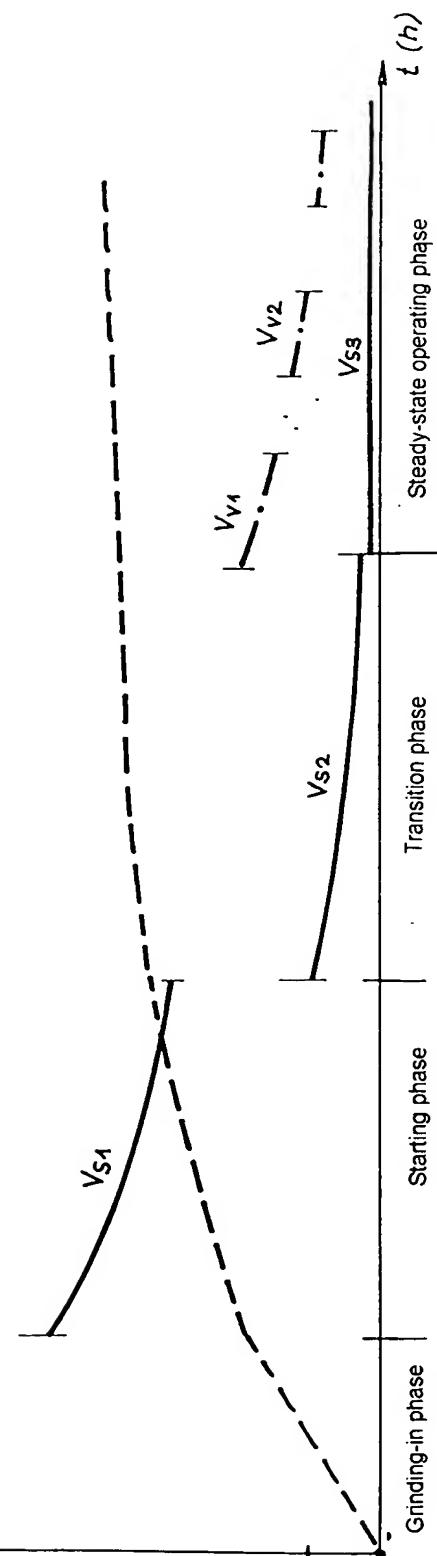
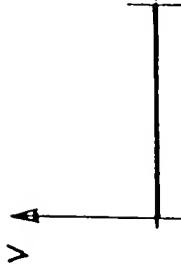


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Fig. 6

Horizontal feed rate v_x (mm/h)
Vertical feed rate v_y (mm/h)
Horizontal side plate wear (mm)



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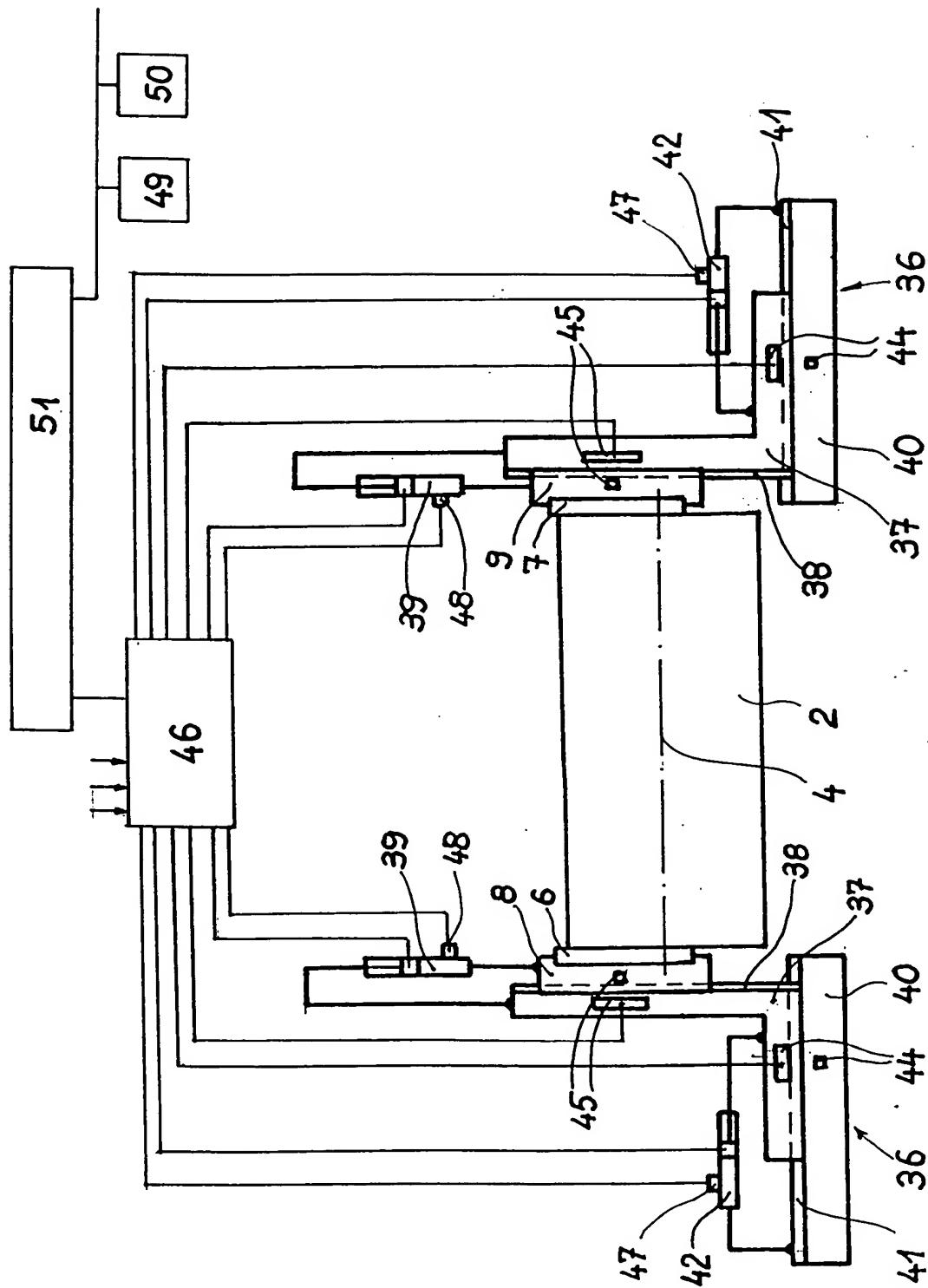


Fig. 7